Dart Aerospace Ltd.

Date: Thursday, 7/3/2008 3:39:15 PM
Kim Johnston

31

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKID RH 206L1,L3,L4&407
Job Number	: 40238		
Estimate Number	: 10328		
P.O. Number	:	Part Number	: D206642512
This Issue	: 7/3/2008 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SKIDTUBES	Drawing Revision	: L
Previous Run	: 36999	Material	:
Written By	:	Due Date	: 7/30/2008 Qty: 1 Um: Each
Checked & Approved By	: KJ 08 07 04		
Comment	: Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM		
	Est Rev:C 07-02-23 As per IIN D206-642 Rev K JLM		
	est rev D 07.06.06 added K642-512 EC		
	Est Rev:E 07-12-05 ECN 1080p Rev L DD verified by:		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

JD 08.7.08

Comment: DOCUMENT CONTROL
Photocopy bluefile and create labels per PPP D206-642-512 CHG003 — S 08/07/31

Seq. #:	Machine Or Operation:	Description :
2.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

Seq. #:	Machine Or Operation:	Description :
3.0	40238A	FLOAT SKIDTUBE ASSEMBLY

S

Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY
1 x D206-642-541 Batch 40238A — SD

Seq. #:	Machine Or Operation:	Description :
4.0	K642 512	saddle kit 642-511

S B37361 (1x)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
saddle kit 642-512 — 8/7/31 SD

Seq. #:	Machine Or Operation:	Description :
5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS — S 08/07/31 (SD)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5/2

Dart Aerospace Ltd.

Date: Thursday, 7/3/2008 3:39:50 PM
User: Kim Johnston

31

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 40238A
Estimate Number : 10309
P.O. Number :
This Issue : 7/3/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : SKIDTUBES
Previous Run : 40237A
Written By :
Checked & Approved By : 08 07.04

Drawing Name : FLOAT SKIDTUBE ASSEMBLY
Part Number : D206642541
Drawing Number : D3274 REV D
Project Number : N/A
Drawing Revision : D
Material :
Due Date : 7/30/2008 Qty: 1 Um: Each

Comment : Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
Est Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
Est Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
Est Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
Est Rev:F 08-06-02 add comment DD verified by:EC

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPP D206-642-541 CHG003 N/A

Seq. #:	Machine Or Operation:	Description :
2.0	D26001190	Extrusion Round 3" 206

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2600-1-190 3" OD Tube B31032 BE 08/07/22

Seq. #:	Machine Or Operation:	Description :
3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274 BE 08/07/22

2- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end. BE 08/07/23

3-Drill #40 Aft cap pilot hole using DT8025 BE 08/07/23

4-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274 BE 08/07/23

5-Remove inner indexing ridge on fwd and aft end of skidtube as per Dwg D3274 BE 08/07/22

6-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end. BE 08/07/23

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ____________________ **NCR:** Yes No **DQA:** _____ **Date:** __________

QA: N/C Closed: _____ **Date:** __________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/3/2008 3:39:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** FLOAT SKIDTUBE ASSEMBLY

Job Number: 40238A | **Part Number:** D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
14.0	D32751	Crossbolt Spacer

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:
Qty Part Number Description Batch
12 D3275-1 Crossbolt spacer B35210 BE 08/07/28

Seq. #:	Machine Or Operation:	Description :
15.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod
A/R Aluminum Rod m107877 BE 08/07/28

3-Grind cross bolt welds flush as per Dwg D3274. H 8-7-29

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr. PTO BE 08/07/28

Seq. #:	Machine Or Operation:	Description :
16.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 08/07/28

Seq. #:	Machine Or Operation:	Description :
17.0	QC10	VISUAL INSPECTION OF GROUND WELDS

Comment: VISUAL INSPECTION OF GROUND WELDS 08/07/26

Seq. #:	Machine Or Operation:	Description :
18.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Pressure wash as per QSI 005 08-07-29

Seq. #:	Machine Or Operation:	Description :
19.0	POWDER COATING	POWDER COATING

M108523 (1X)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 10:50
OVEN TEMPERATURE: 320
FINISH TIME: 11:20

08/07/29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-541 PAR #: N/A Fault Category: Prod/Skidtube NCR: (Yes) No DQA: [initials] Date: 08/08/01

QA: N/C Closed: [initials] Date: 08/08/01

NCR: 40238 A		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
8/7/28	15.4	During counter boring the counter bore shifted to one side and counter sunk the 10th hole from Aft.	08/10/12	Drill out affected ~~bolt~~ spacer Replace D2649 B# 39883 add re weld as per OS 7004	BE 08/07/28 BE 08/07/28	08/07/20	08/1/02	08/07/28
		RC Todd Sommers		A/R# M107877				08/07/28

NOTE: Date & initial all entries

Date: Thursday, 7/3/2008 3:39:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** FLOAT SKIDTUBE ASSEMBLY

Job Number: 40238A | **Part Number:** D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
20.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION   08/07/30

21.0	D3415041	Nut Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3415-041	Nut Plate	B33842

22.0	CCR264SS33	Cherry Rivet

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	CCR264SS3-3	Rivet	M101938

23.0	CR3212403	Cherry Rivet

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	CR3212-4-03	Rivet	M15918

24.0	ALS71032130	Insert

Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)
Insert
Batch: M10S819

25.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.
A/RN/ALPS-3 M104231

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a   08/07/30

Form: rrprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 40238A
Part Number: D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
	A/R Sikaflex-291 m107888 Sikaflex expire date: 08/11	
26.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP Inspect Nut Plate & Inserts	8/7/30
27.0	AN3C4A	BOLT
	Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s) BOLT Batch: m108599	
28.0	D353515	Wearshoe
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: B37810	
29.0	D353523	Wearshoe
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: B39134	
30.0	D353535	Wearshoe
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: B39233	
31.0	D353539	Wearshoe
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: B37277	
32.0	D353615	Gasket
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) GASKET Batch: B33964	08/07/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Thursday, 7/3/2008 3:39:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 40238A
Part Number: D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
33.0	D353623	Gasket

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: 33965
RK/FL

34.0	D353635	Gasket

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: 38183
RK/FL

35.0	D353639	Gasket

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: B339 66
RK/FL

36.0	D35371	Wearpad

Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)
WEARPAD
Batch: 38941
RK/FL

37.0	D35373	Wearpad

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPAD B 3381
RK/FL

38.0	AN960C10L	washer

Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
80	AN960C10L	Washer	M108672

RK/FL

39.0	D36721	Phenolic Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
batch B39275
RK/FL 08/07/30

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/3/2008 3:39:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 40238A

Part Number: D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
40.0	D34131	Ring

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3413-1	Ring	D33949

Seq. #:	Machine Or Operation:	Description :
41.0	AN4C5A	BOLT

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	AN4C5A	Bolt	M104936

Seq. #:	Machine Or Operation:	Description :
42.0	AN960C416	washer

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	AN960C416	Washer	M100993

Seq. #:	Machine Or Operation:	Description :
43.0	D2646	Aft Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	D37377

Seq. #:	Machine Or Operation:	Description :
44.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274
A/R Sikaflex-291 M107888
Sikaflex expire date: 08/11

4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3
A/R LPS-3 Batch: M106096

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

08/07/30

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Thursday, 7/3/2008 3:39:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 40238A
Part Number: D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
	A/R Sikaflex-291 MCO 7888 Sikaflex expire date: 08/11	08/07/30
45.0	QC5	INSPECT WORK TO CURRENT STEP 08/07/30
	Comment: INSPECT WORK TO CURRENT STEP	
46.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and stock Location: 40238	8/7/31
47.0	QC21	FINAL INSPECTION/W/O RELEASE 08/07/31
	Comment: FINAL INSPECTION/W/O RELEASE	

Job Completion — MF 08-07-31

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3274 — REV. D — SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY — SCALE NTS

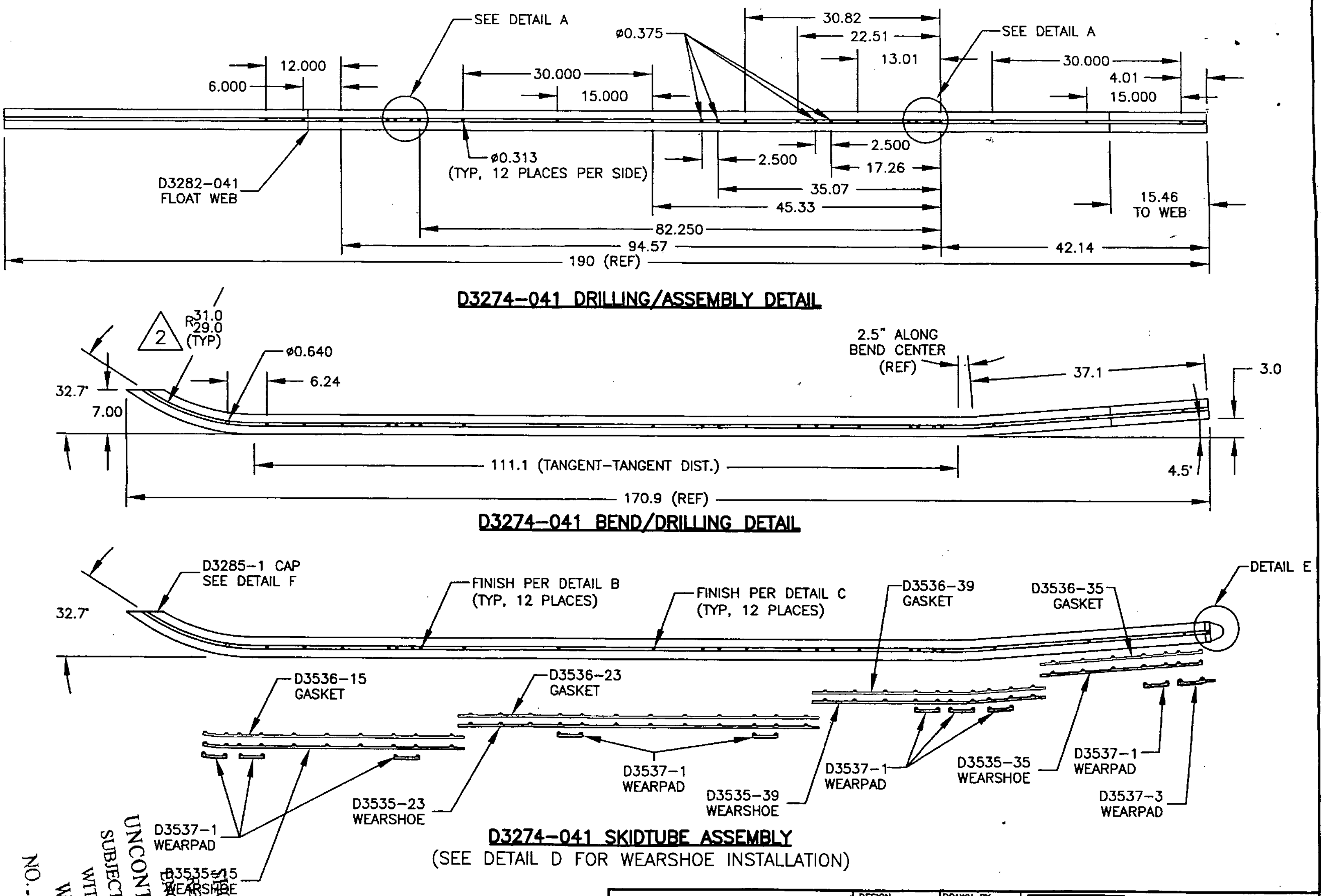
A	04.03.15	NEW ISSUE
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76
C	05.03.16	ADD −043; NEW INSERTS
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET

RELEASED 07.02.12

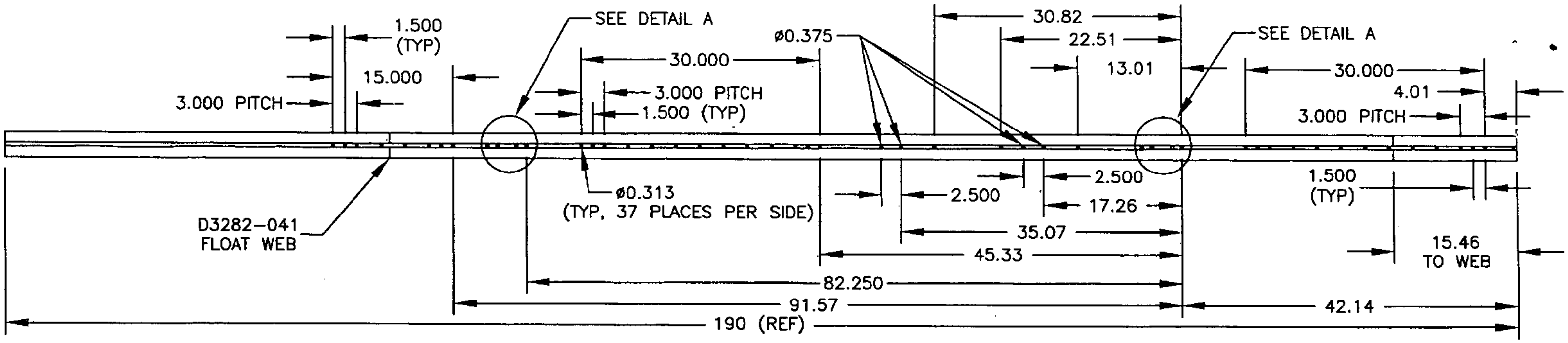
Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

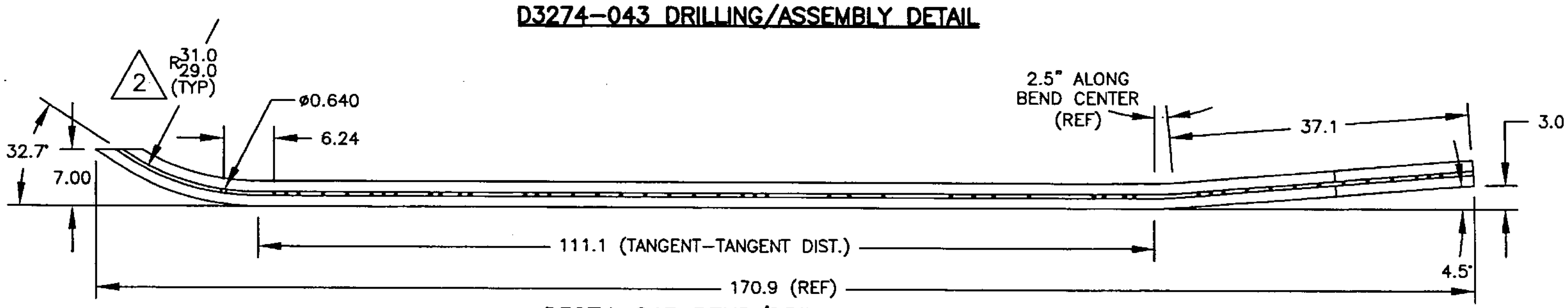
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
   THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
   - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL ∅0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.



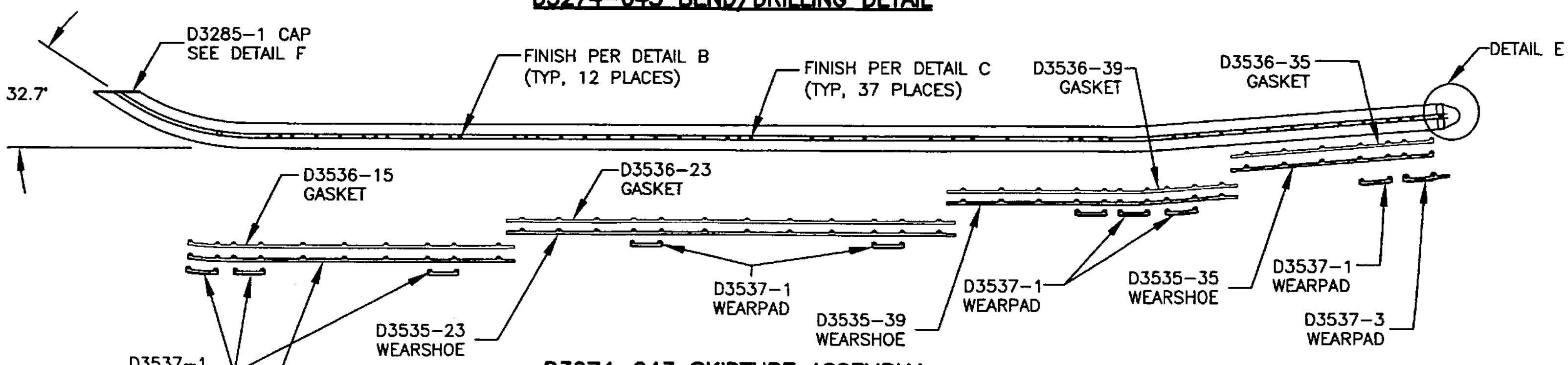
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CP	PH		
CHECKED	APPROVED	DRAWING NO. D3274	REV. D SHEET 2 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE 1:15



D3274-043 DRILLING/ASSEMBLY DETAIL



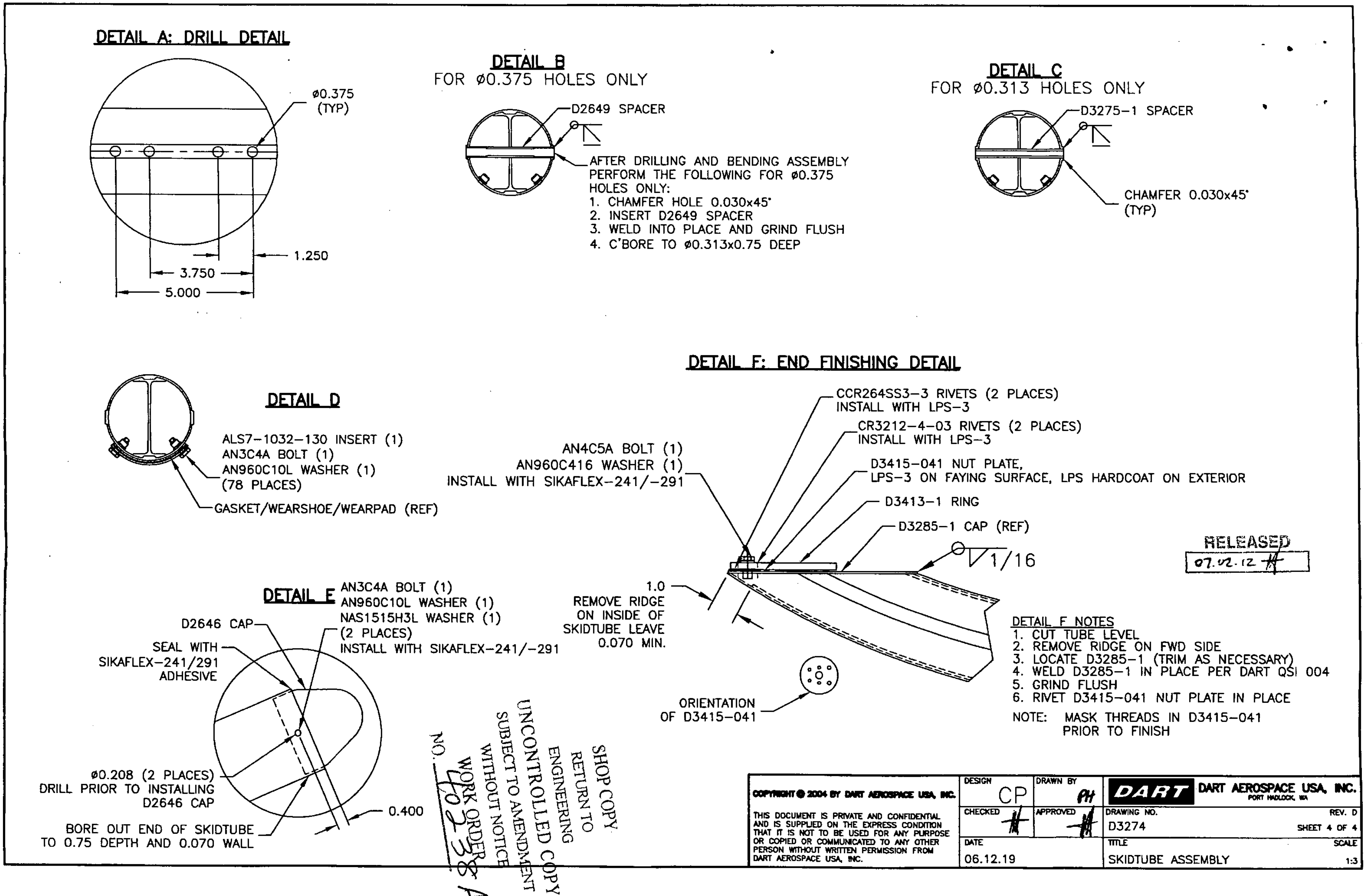
D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CP	PH		
CHECKED	APPROVED	DRAWING NO. D3274	REV. D SHEET 3 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE 1:15



DETAIL A: DRILL DETAIL
ø0.375 (TYP)
1.250
3.750
5.000
DETAIL B
FOR ø0.375 HOLES ONLY
D2649 SPACER
AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO ø0.313x0.75 DEEP
DETAIL C
FOR ø0.313 HOLES ONLY
D3275-1 SPACER
CHAMFER 0.030x45° (TYP)
DETAIL D
ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)
DETAIL F: END FINISHING DETAIL
CCR264SS3-3 RIVETS (2 PLACES) INSTALL WITH LPS-3
CR3212-4-03 RIVETS (2 PLACES) INSTALL WITH LPS-3
AN4C5A BOLT (1)
AN960C416 WASHER (1)
INSTALL WITH SIKAFLEX-241/-291
D3415-041 NUT PLATE, LPS-3 ON FAYING SURFACE, LPS HARDCOAT ON EXTERIOR
D3413-1 RING
D3285-1 CAP (REF)
1/16
1.0
REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN.
ORIENTATION OF D3415-041
DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH
RELEASED
07.02.12
DETAIL E
AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291
D2646 CAP
SEAL WITH SIKAFLEX-241/291 ADHESIVE
ø0.208 (2 PLACES) DRILL PRIOR TO INSTALLING D2646 CAP
BORE OUT END OF SKIDTUBE TO 0.75 DEPTH AND 0.070 WALL
0.400
SHOP COPY RETURN TO ENGINEERING
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DESIGN CP
DRAWN BY PH
CHECKED
APPROVED
DATE 06.12.19
DART
DART AEROSPACE USA, INC.
PORT HADLOCK, WA
DRAWING NO. D3274
REV. D
SHEET 4 OF 4
TITLE SKIDTUBE ASSEMBLY
SCALE 1:3

NO. 163

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 0 40394
Part number: 206 042 141
Description: 206 skid tube
Welding Process: Tig[✓] Mig[ ]
Base materiel: Aluminium
Current: AC[✓] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[✓]	fail[ ]
Penetration:	pass[✓]	fail[ ]

UNACCEPTABLE

Cracks:	pass[✓]	fail[ ]
Undercut:	pass[✓]	fail[ ]
Pin holes:	pass[✓]	fail[ ]
Overlap (cold lap)	pass[✓]	fail[ ]
Porosity (surface):	pass[✓]	fail[ ]
Coloration:	pass[✓]	fail[ ]

Qualifier [signature] **Date of Test Coupon** 08-07-11

Welder [signature] **Date of Test Coupon** 08-07-11

The above named individual is qualified in accordance with AWS D17.1.2001 to weld